

Date: Thursday, 10/08/2006 10:01:19 AM
 User: Linda Lacelle

Process Sheet

*split into
 SB 07/10/02*

| | | | |
|-----------------------|---|------------------|-------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : N1 GEARBOX ACCESS PANEL KIT |
| Job Number | : 28124 | | |
| Estimate Number | : 12503 | | |
| P.O. Number | : <i>N/A</i> | Part Number | : D3255041 |
| This Issue | : 10/08/2006 S.O. No. : <i>N/A</i> | Drawing Number | : D3255 REV B |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : <i>N/A</i> Type : LARGE FAB ASSY | Drawing Revision | : B |
| Previous Run | : <i>N/A</i> | Material | : <i>N/A</i> |
| Written By | : <i>[Signature]</i> | Due Date | : 31/08/2006 Qty: 4 Um: Each |
| Checked & Approved By | : <i>[Signature]</i> | | |
| Comment | : Est Rev: C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|----|--------|-------|
| 10 | D32551 | Panel |
|----|--------|-------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Panel

Batch: *328837*

Pl 07-10-01

| | | |
|----|--------|-----|
| 20 | D32553 | Cap |
|----|--------|-----|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Cap

Batch: *1721863*

Pl 07-10-01

| | | |
|----|-------------|------------------------------|
| 30 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|----|-------------|------------------------------|



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D3255

A/R SS ROD Batch: *m105138*

2-Grind Welds Flush

Pl 07-10-01

(4)

| | | |
|----|-------|-----------------|
| 40 | QC5/9 | WELD INSPECTION |
|----|-------|-----------------|



Comment: WELD INSPECTION

Pl 07-10-01 (9)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: N1 GEARBOX ACCESS PANEL KIT

Job Number: 28124

Part Number: D3255041

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.1

POWDER COATING

POWDER COATING



M104846



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

SS 07-10-02

6.1

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 07/10/02 (4X)

7.1

D32555

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Gasket

Batch: B26136 x 2mx, B28839 x 2mx

SB 07/10/03

(1)

8.1

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Bond D3255-5 gasket to d3255-041 using Dow corning adhesive as per Dwg D3255

A/R 736

DOW CORNING ADHESIVE Batch: M15064

SB 07/10/03

(1)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/10/03

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/10/03 (1)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Don 07/10/04 (1)

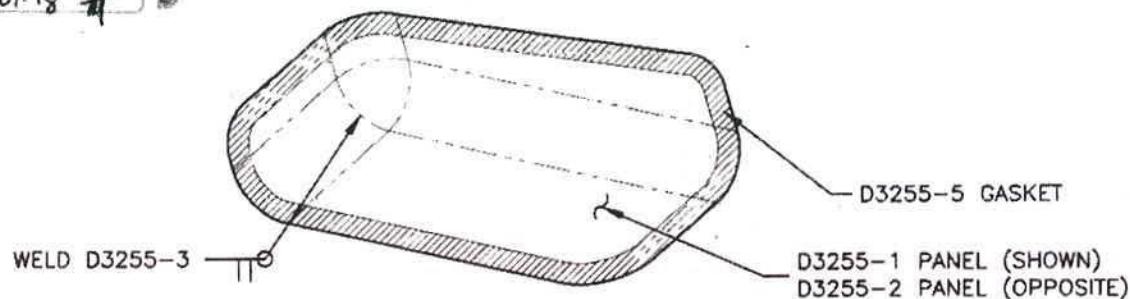
Job Completion



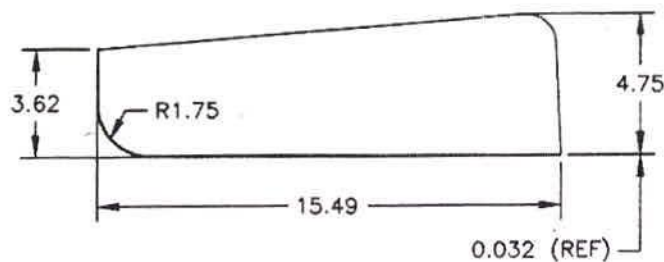
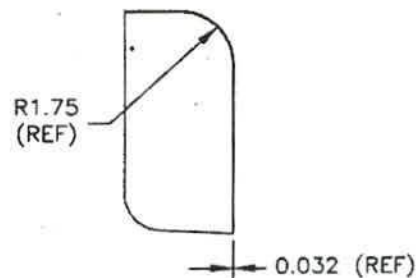
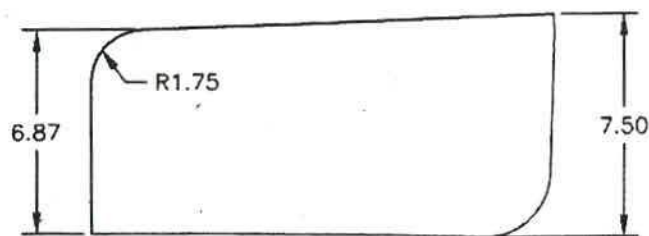
12 07-10-03

DART

| | | | |
|------------------|---------------|---|------------------------|
| DESIGN H | DRAWN BY H | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED UP | APPROVED H | DRAWING NO. D3255 | REV. B SHEET 1 OF 4 |
| DATE 04.12.06 | | TITLE ACCESS PANEL ASSEMBLY | SCALE 1:6 |
| A | 04.01.27 | NEW ISSUE | |
| B | 04.12.06 | D3255-3 REDESIGN; ADDED $\phi 0.098$ | |

RELEASED
05-01-18

D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|--------------------|----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 02/10/02 | 8 | Split 4/0 | SB | 02/10/02 | 1 | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries